

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015199**Date Inspected:** 24-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Mike Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR Test Plate**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe and witness the welding of a Procedure Qualification Record (PQR) test plate and monitor the Quality Control (QC) functions.

This QA Inspector was informed by QC Mike Johnson and ABF Welding Supervisor Danny Ieraci (#3232) that ABF welding personnel Rick Clayborn (#2773) would be performing the welding and that welding would start at approximately 0800 hours. While waiting for the PQR to begin this QA Inspector was provided a copy of the following documents by QC Inspector a Mike Johnson: Material Test Report (MTR) for the plate material, MTR for the backing material, manufacturers recommended range of welding parameters for the electrode to be used, manufactures certification for the electrode and an example Welding Procedure Specification (WPS) for the proposed welding parameters. This QA Inspector reviewed the documents and observed they appeared to comply with the contract requirements.

This QA Inspector was informed by QC Inspector Mike Johnson at approximately 0830 hours that ABF welding personnel Rick Clayborn (#2773) had been assigned a welding task on the temporary tower for the tower crane and would not be available to start the PQR until later this date. This QA Inspector examined the test plates stacked on a pallet next to the shelter where the PQR was to be welded and observed the heat numbers on the MTR's provided were clearly marked on the plates that were visible at this time. This QA Inspector performed a random check of the angles cut on the top plates and observed they appeared to comply with the applicable joint design detailed on the WPS provided.

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This QA Inspector was informed by QC Inspector Mike Johnson at approximately 1000 hours that ABF welding personnel Rick Clayborn (#2773) would start fitting up the test plates after the morning break. Please see Welding Witness Report (TL-6032) this date for further details.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
